

Work Order ID 81444

81444

Page 1

Wednesday, March 14, 2012 10:57:47 AM

Item ID: D3916-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly
 Start Date: 3/14/2012 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 3/30/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: ME Date: 12-03-14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								

100

0.00

100

Large Fab

Large Fab

Memo

0.00

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D3916
- 4- Drill and chamfer holes as per dwg D3916-1 using DT9605

(6) SFD 120326

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Quality Control

Memo

0.00

Sy 12.03.27 (6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81444

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N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

12

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

Weld per dwg A/R S.S. rod Batch: _____

0.00

107

4115778

0.00

Large Fab

Memo

Large Fab

1- weld bushing as per dwg D3916
2- grind welds flush

110

QC5- Inspect part completeness to step on W/O

0.00

110

5/2/78

QC

Memo

0.00

Quality Control

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

8.2/3/78

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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81444

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

12

12

Customer:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

LD 12.03.27 (6x)

12/3/2998

Q12-03-28

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, March 14, 2012 10:57:47 AM

Page 1

Work Order ID: 81444

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC
verified by:EC

IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			100	Each	315.0000	7	84		12-03-26	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		203							
				79213		203							
				WA005		112							
				66489		1							
				74783		111							
M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	443.0184	4.166	52.623158		12-03-26	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT018		418.2411429							
				117775		93.6739							
				118472		47.1990839							
				118880		0.2736							
				119147		76.4906							
				119643		39.6981							
				120494		160.905859							
				MAT034		1.8507							
				117337		1.8507							
				WA035		22.92654							
				118184		22.92654							

121022

26.3116

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

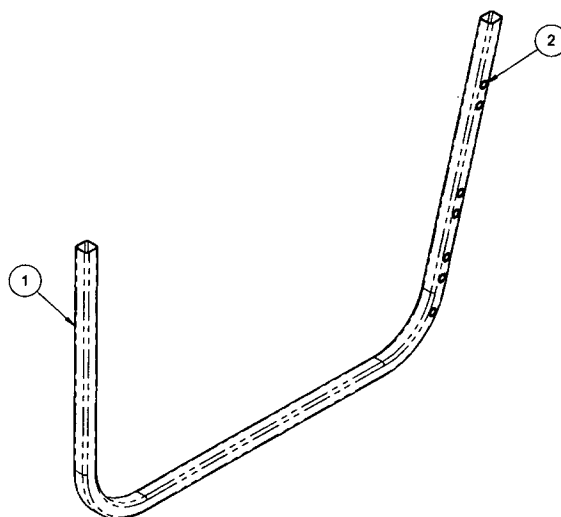
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

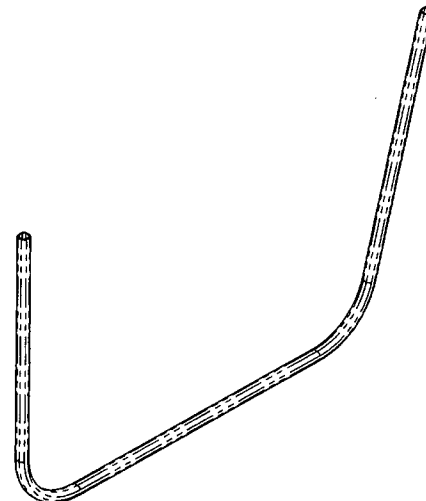
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

81444

OL 10.12.21
 UNDER REVIEW
 10.10.11
 ADDITION OF HOLE + BUSHING
 on D3916-041 RIBS.
RELEASED
 2010-03-12
 JWP

A	NEW ISSUE	DESCRIPTION	JPH	10.03.04
REV.			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.		REV. A
MFG. APPR.	<i>[Signature]</i>	D3916		SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE		SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET		NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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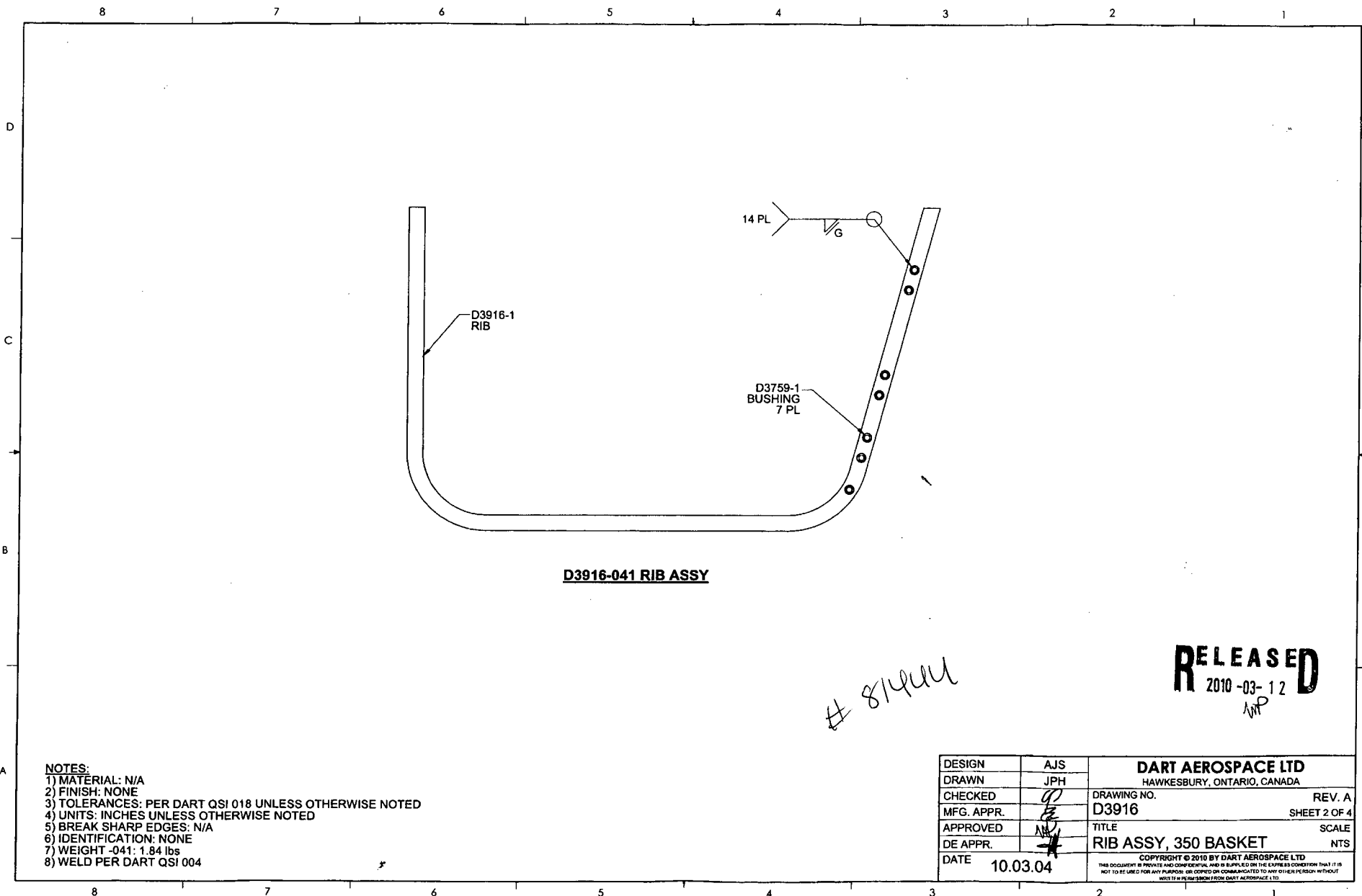
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NOTE: Date & initial all entries



D3916-041 RIB ASSY

81444

RELEASED
2010-03-12
ANT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
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DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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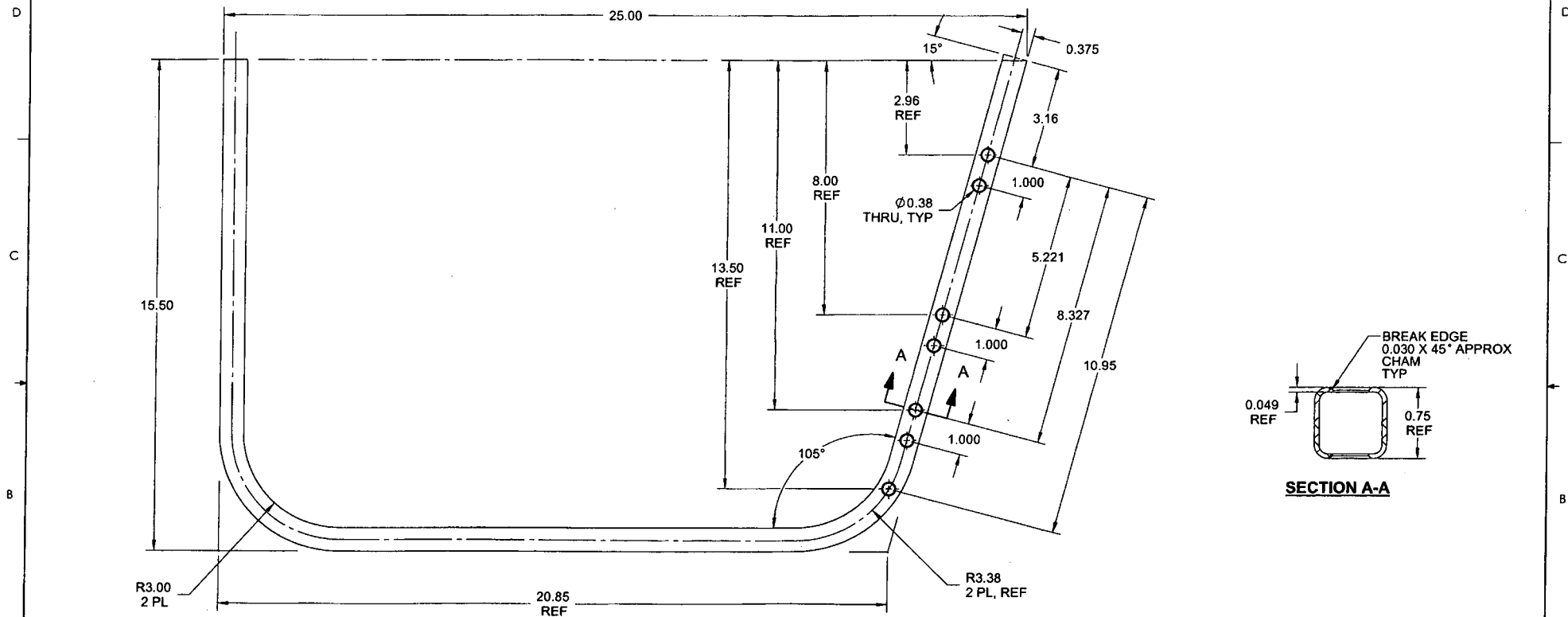
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



9 D3916-1 RIB

#81444

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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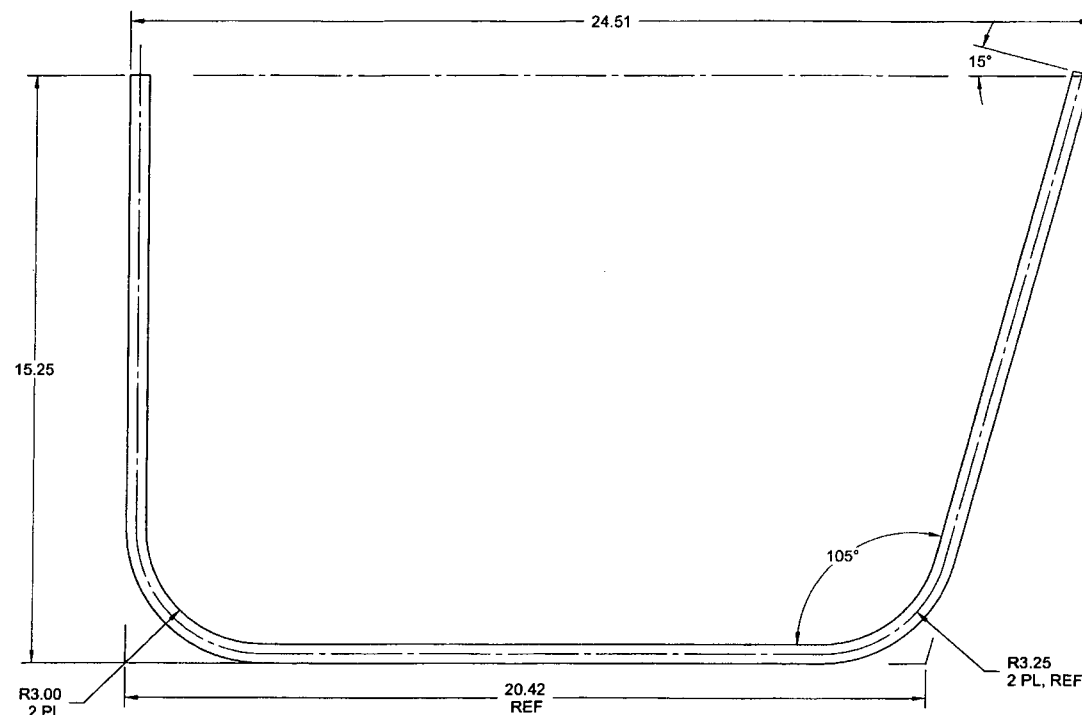
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



9 D3916-5 LIGHT RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

#87444

RELEASED
2010-03-12
M

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	W	DRAWING NO.	REV. A
MFG. APPR.	E	D3916	SHEET 4 OF 4
APPROVED	M	TITLE	SCALE
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